

Instructions For Use

Version 1.0.1

Tapping chuck

Item no.

3050702

3050705

3050709

3050706

3050710

Scope of delivery

Application area

Assembly

Operation

Cleaning, Maintenance

Tapping chuck dimensions

Square sizes



Preface

Thank you very much for purchasing a product made by OPTIMUM.

1 Scope of delivery

- 3050702 , Tapping chuck MT2 / M3-M12 in aluminium box
- 3050705 , Tapping chuck MT3 / M3-M12 in aluminium box
- 3050706 , Tapping chuck MT3 / M8-M20 in aluminium box
- 3050709 , Tapping chuck MT4 / M3-M12 in aluminium box
- 3050710 , Tapping chuck MT4 / M8-M20 in aluminium box

2 Application area

Can be used for cutting and forming internal threads in a horizontal or vertical position on reversible drilling machines, tapping machines, radial drilling machines and lathes.

3 Assembly

Keep the tool holder in the machine spindle clean. When changing tools, hold the tool firmly so that the tool does not fall off when it is loosened. This can damage the tool and workpiece.

Observe the tool dimensions and information of the machine manufacturer.

Do not disassemble the tapping chuck and do not make any changes. This can lead to damage and malfunction!

4 Operation

Tool change only with stationary spindle!

Length compensation

The length compensation compensates the differences between the pitch of the thread tap and the machine feed or manual feed. If possible, it should always easily worked in a pulling range of the thread tap. The feed should therefore about 5% smaller.

5 Cleaning, Maintenance

We recommend to clean the tapping chuck at regular intervals depending on the degree of soiling with a handclap.

- Do not use aggressive solvents.
- Do not use fibrous materials such as e.g. cotton wool.

The tapping chuck is maintenance-free, but should faults occur, do not continue to use the tapping chuck.

6 Tapping chuck dimensions

Please note, there are at least 6 different DIN standards on taps and 5 different ISO standards. So which tap fits into the tapping chuck depends on your ISO or DIN type of tap used.

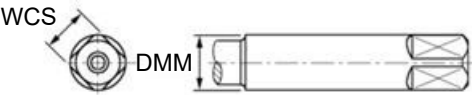
Designation	Shaft diameter [mm]	Square dimension [mm]
M3 / M3.5	2.5	2.1
M4	2.8	2.1
M4.5 / M5	3.5	2.7
M6	4.5	3.4
M7 / M8	6	4.9
M10	7	5.5
M12	9	7
M14	11	9
M16	12	9
M18	14	11
M20	16	12

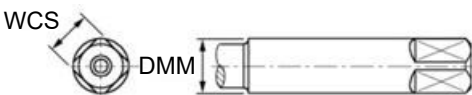
7 Square sizes

The size of the square depends on the shank diameter of the hand tap.

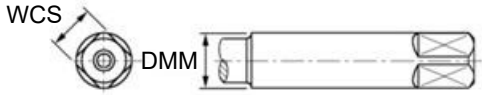
ISO Shank and square dimensions						
Shank diameter (DMM), mm	Square (WCS), mm	ISO 529 Metric	ISO 529 UNC/UNF BSWBSF	ISO 2283 Metric	ISO 2284 G	ISO 2284 Rc
2.5	2.00	M1				
		M1.2				
		M1.4				
		M1.6	Nr. 0			
		M1.8				
		M2	Nr. 1			
2.8	2.24	M2.2	Nr. 2			
		M2.5	Nr. 3			
3.15	2.50	M3	Nr. 4	M3		
			Nr. 5			
3.55	2.80	M3.5	Nr. 6	M3.5		
				M4		
4.00	3.15	M4		M5		
4.50	3.55	M4.5	Nr. 8	M6		
5.00	4.00	M5	Nr. 10 3/16			
5.60	4.50	M5.5	Nr. 12 7/32	M7		

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ISO Shank and square dimensions						
Shank diameter (DMM), mm	Square (WSC), mm	ISO 529 Metric	ISO 529 UNC/UNF BSWBSF	ISO 2283 Metric	ISO 2284 G	ISO 2284 Rc
6.30	5.0	M6	1/4	M8		
7.10	5.60	M7	9/32			
8.00	6.30	M8	5/16	M10	G 1/8	Rc 1/8
9.00	7.10	M9		M12		
10.00	8.00	M10	3/8		G 1/4	Rc 1/4
8.00	6.30	M11	7/16			
9.00	7.10	M12	1/2			
11.20	9.00	M14	9/16	M14		
12.50	10.00	M16	5/8	M16	G 3/8	Rc 3/8
14.00	11.20	M16 M20	11/16 3/4	M18 M20		
16.00	12.50	M22	7/8	M22		
18.00	14.00	M24	1"	M24	G 5/8	Rc 5/8
20.00	16.00	M27 M30	1 1/8	M27 M30	G 3/4	Rc 3/4
22.40	18.00	M33	1 1/4		G 7/8	Rc 7/8
25.00	20.00	M36	1 3/8		G 1"	Rc 1"
28.00	22.40	M39 M42	1 1/2			

DIN shank and square dimensions							
Shank diameter (DMM), mm	Square (WSC), mm	DIN 352	DIN 371	DIN 376	DIN 374	DIN 2182	DIN 2183
2.5	2.10	M1	M1				
		M1.1	M1.1				
		M1.2	M1.2	M3.5	M3.5	1/16	
		M1.4	M1.4				
		M1.6	M1.6				
		M1.8	M1.8				
2.8	2.10	M2					
		M2.2		M4	M4	3/32	5/32
		M2.5	M2.5				
3.20	2.40						3/16

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DIN shank and square dimensions							
Shank diameter (DMM), mm	Square (WCS), mm	DIN 352	DIN 371	DIN 376	DIN 374	DIN 2182	DIN 2183
3.50	2.70	M3	M3	M5	M5		
4.00	3.00	M3.5	M3.5			1/8	
4.50	3.40	M4	M4	M6	M5.5	5/32	1/4
6.00	4.90	M5 M6 M8	M5 M6	M8	M8	3/16	5/16
7.00	5.50	M10		M10	M9 M10	1/4	3/8
8.00	6.20		M8			5/16	7/16
9.00	7.00	M12		M12	M12	3/8	1/2
10.00	8.00		M10				
11.00	9.00	M14		M14	M14		9/16
12.00	9.00	M16		M16	M16		5/8
14.00	11.00	M18		M18	M18		3/4
16.00	12.00	M20		M20	M20		
18.00	14.50	M22 M24		M22 M24	M22 M24		7/8
20.00	16.00	M27		M27	M28 M28		1"
22.00	18.00	M30		M30	M30		1 1/8
25.00	20.00	M33		M33	M33		1 1/4
28.00	22.00	M36		M36	M36		1 3/8

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